

Date: Monday, 12/01/2009 11:14:16 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L WEB
Job Number	: 44549		
Estimate Number	: 10722		
P.O. Number	:	Part Number	: D26547
This Issue	: 12/01/2009 S.O. No. :	Drawing Number	: D2654 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SKIDTUBES	Drawing Revision	: E1
Previous Run	: 44231	Material	:
Written By	:	Due Date	: 16/01/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>JWD 09.01.12</u>		
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedureDM Est Rev:e 06.04.05 Added level21 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26007140	EXT. "I BEAM" THICK
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-7- 140	Web	B41591

Q.m 09.01.12 (4)

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

Q.m 09.01.12 (4)

2-Drill pilot holes in web using drill jig DT 8018-7 as perDwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

P.m 09-01-12

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Q.m 9-1-12

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.m 9-1-12

(4)

(4)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 44549

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

9-1-12

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Spid tube

DP

9-1-12

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14

Job Completion



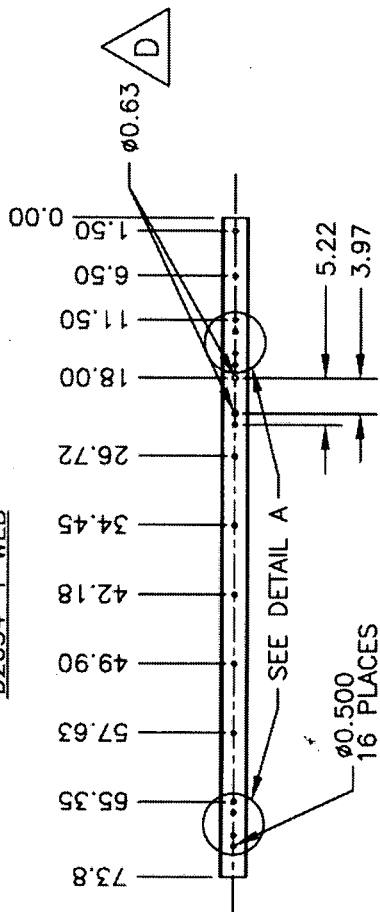
MF 09-01-13



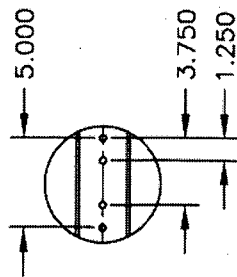
DESIGN	AP	DRAWN BY	AP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	##	APPROVED	##	DRAWING NO. D2654
				REV. E SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE 1:20
A	97.03.25	NEW ISSUE		
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29	CHANGED HOLE PATTERN		
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26	CHANGE LENGTHS, REFORMAT		
E1	04.08.04	PER TOOLING; 80.8 WAS 80.5		

RELEASED  
04.06.22

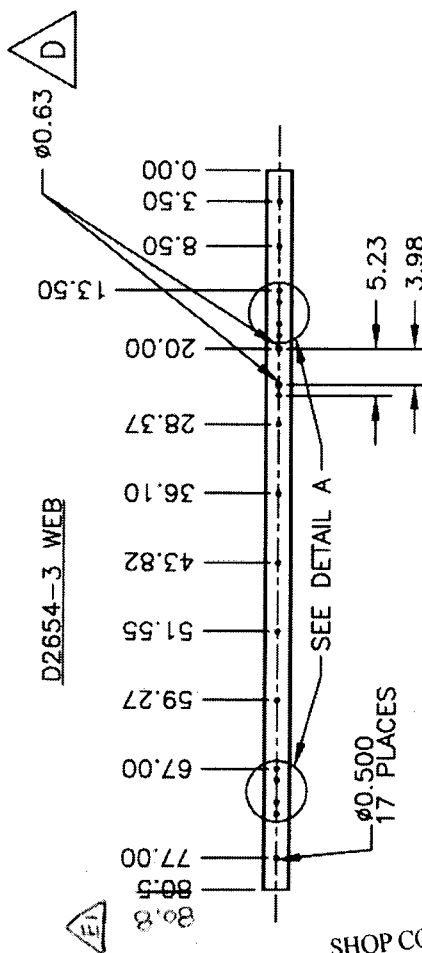
D2654-1 WEB



DETAIL A  
SCALE 1:10



D2654-3 WEB



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NO. 44547

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

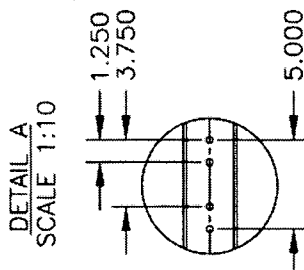
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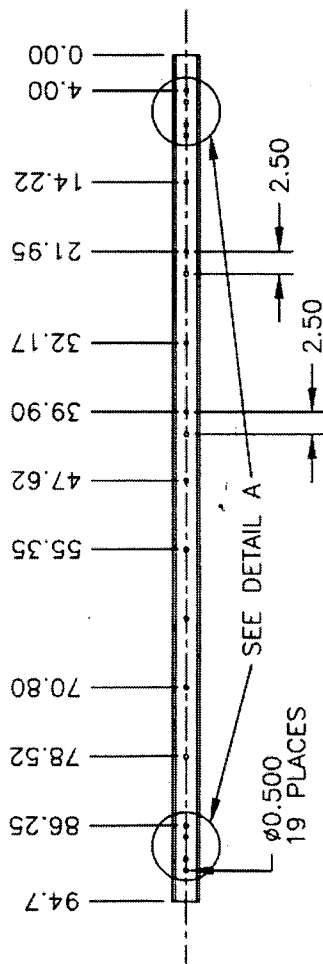


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

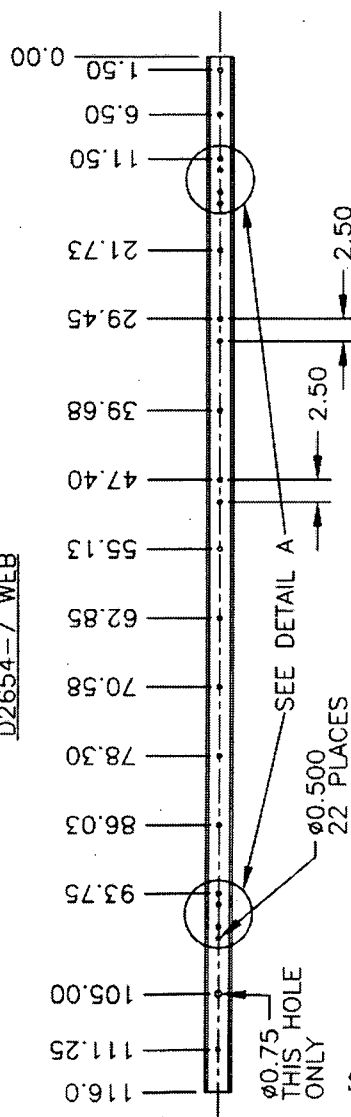
RELEASED  
04.02.22



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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